

Date: Wednesday, 3/14/2007 3:32:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HOOK
Job Number	: 31229		
Estimate Number	: 12597		
P.O. Number	: N/A	Part Number	: D30465
This Issue	: 3/14/2007 S.O. No. : N/A	Drawing Number	: D3046 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/14/2007 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31095	Material	: N/A
Written By	: <u>07.0315</u>	Due Date	: 3/30/2007
Checked & Approved By	: <u>07.0315</u>	Qty:	30 Um: Each
Comment	: Est A 06.12.01 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B0375X1000	17-4 SS Bar 3/8 x 1"
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Comment: Qty.: 0.1397 f(s)/Unit Total : 4.1895 f(s)
 17-4PH Stainless Steel Bar 3/8" x1.00"
 Batch: M102942

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank 1.600" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA659 Rev: AA & Dwg D3046 Rev: B

2-Deburr per dwg D3046

J.F. 07/03/21

(29)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/03/21

(29)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L. 07/03/22

29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/13/26

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:32:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOOK

Job Number: 31229

Part Number: D30465

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 7/3/23

SS

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(29)

Comment: FINAL INSPECTION/W/O RELEASE

D07/23/26

Job Completion



U 07.02.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

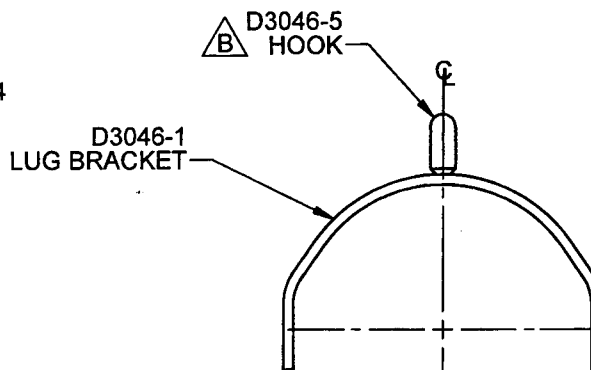
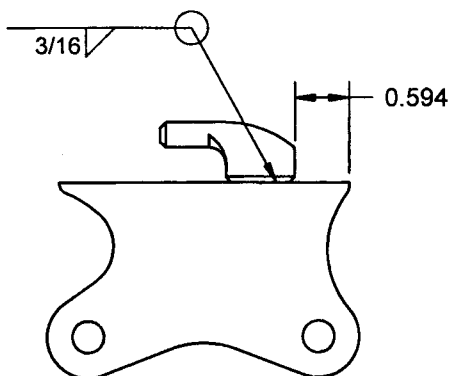
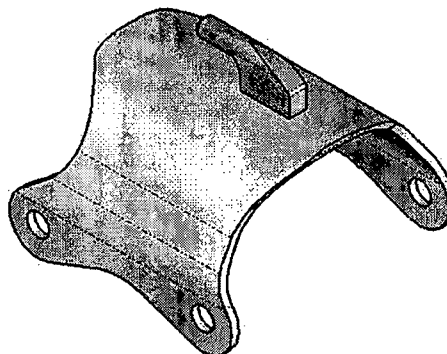
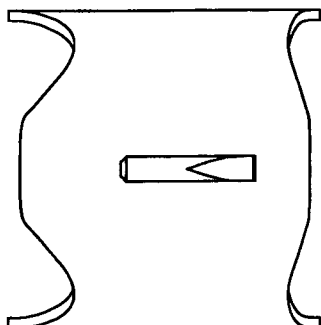
NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 1 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 01.08.23	DESCRIPTION NEW ISSUE	
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL	

RELEASED

06.11.13



D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK

B

NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI)
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER NO. 31229

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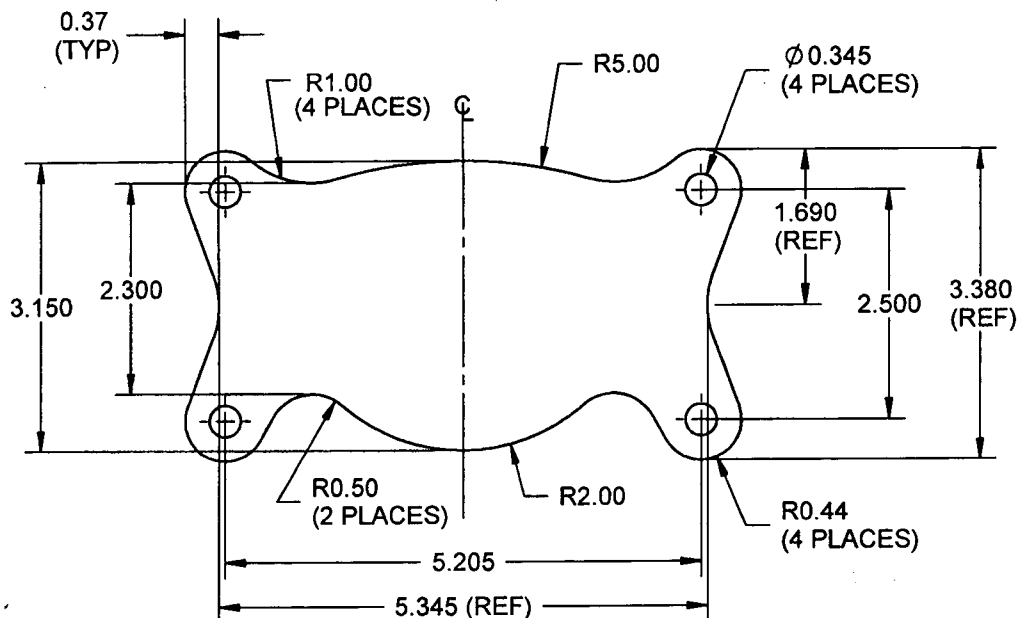
WORK ORDER

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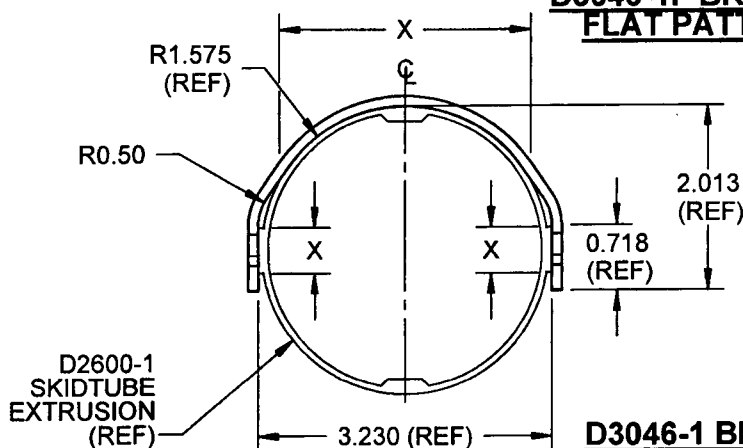
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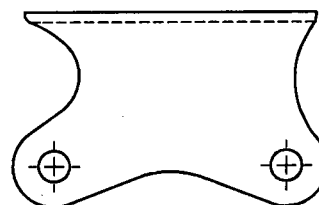
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 2 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY SCALE 1:2		



**D3046-1F BRACKET
FLAT PATTERN**



**D3046-1 BRACKET
BEND DETAIL**

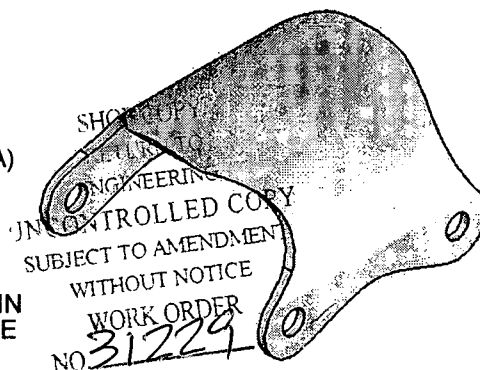


RELEASED

06/11/13

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.



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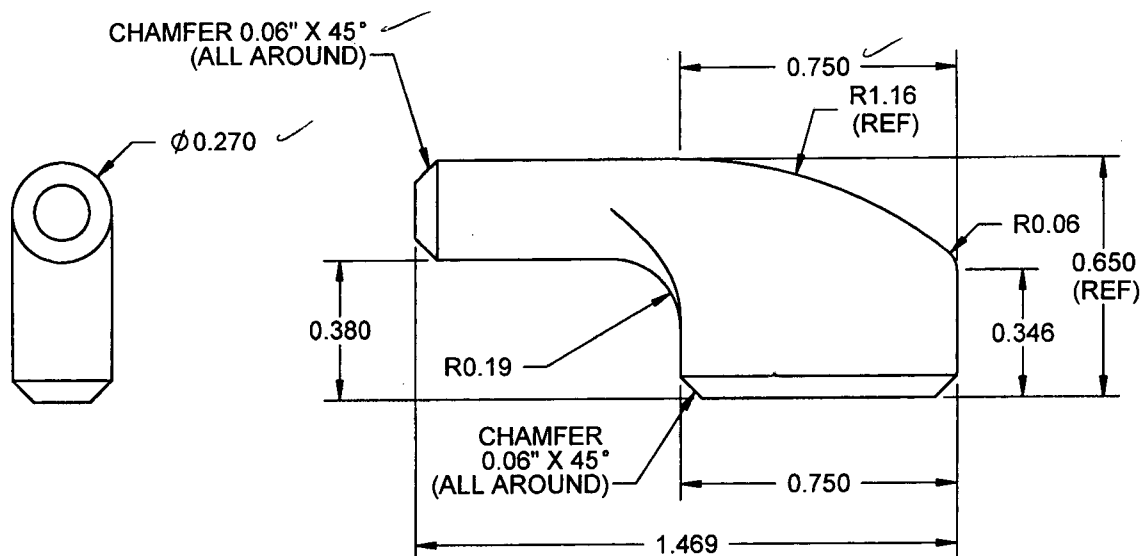
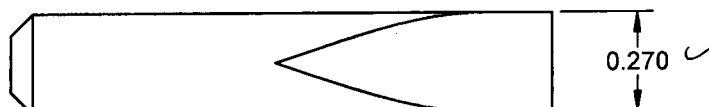
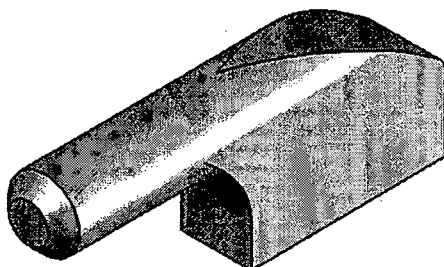
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 2:1

RELEASED

06.11.13



D3046-5 HOOK

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643 (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 31229
Description: Lug bracket assembly		Part Number: 3046-5
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	,270"	$\pm .010"$,273"	✓			
B	,060" x 4.5°	$\pm .030"$,065"	✓			
C	Ø ,270"	$\pm .010"$,272"	✓			
D	,750"	$\pm .010"$,750"	✓			
E	,650"	$\pm .010"$,647"	✓			
F	,346"	$\pm .010"$,346"	✓			
G	,750"	$\pm .010"$,753"	✓			
H	1,469"	$\pm .010"$	1,467"	✓			
I	0,06" x 4.5°	$\pm .030"$,050"	✓			
J	,380"	$\pm .010"$,376"	✓			
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: J.F.	Audited by: En	Prototype Approval:	N/A
Date: 07/03/20	Date: 07/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	